

AMENDMENT TO THE CLAIMS

1. (Currently amended) A method for manufacturing a product having various diameters from a workpiece, in which the workpiece is clamped down in a clamping device, the workpiece and a ~~first set of forming rollers tool~~ are rotated about an axis of rotation relative to each other, wherein the rollers of the first set take up the same axial position with respect to the work piece, wherein the workpiece is deformed by means of said forming rollers first-tool by placing the first ~~tool~~ forming rollers into contact with the workpiece and moving the workpiece and/or the forming rollers first-tool in a direction along said axis of rotation, wherein at least a second set of forming rollers tool ~~is placed into contact with the workpiece at a position behind the first tool, the workpiece is also deformed by means of said second tool and wherein two or more forming rollers associated with the first or second tool~~ positioned at a same axial position with respect to the work piece is placed into contact with the workpiece at a position behind the first set of forming rollers, the workpiece also being deformed by means of said second set of forming rollers and wherein two or more forming rollers, each being of a different set and taking up a different axial position with respect to the work piece, are mounted on a common holder and said holder is rotated about an axis which crosses said axis of rotation and/or radially adjusted during operation.

2. (Cancelled)

3. (Cancelled)

4. (Cancelled)

5. (Cancelled)

6. (Currently amended) The method according to claim 1, wherein at least a third ~~set of~~ set of

forming rollers are is placed into contact with the workpiece at a position behind the second tool.

7. (Currently amended) The method according to claim 1, wherein the ~~tools~~-first and second set of forming rollers each comprise two or more forming rollers, between which the workpiece is retained while being worked.

8. (Previously presented) The method according to claim 1, wherein the workpiece is formed into a finished or semifinished product in only one working cycle.

9. (Previously presented) The method according to claim 1, wherein a tensile force is exerted on the workpiece.

10. (Previously presented) The method according to claim 9, wherein said tensile force is varied during said working.

11. (Currently amended) The method according to claim 1, wherein at least one of the ~~tools~~-first or second set of forming rollers is adjusted in a radial direction during said working.

12. (Currently amended) The method according to claim 1, wherein the workpiece has an open end, which end is closed by means of the ~~tools~~ forming rollers.

13. (Currently amended) The method according to claim 1, wherein the workpiece is a plate-shaped body, and wherein the central axis of the ~~tools~~-holders is pivoted relative to the axis of rotation.

14. (Currently amended) The method according to claim 13, wherein the ~~tools~~-first and second set of forming rollers are moved relative to each other during said working.

15. (Previously presented) The method according to claim 13, wherein the edge of the workpiece is supported at least during part of the operation.

16. (Currently amended) A forming machine suitable for manufacturing products having various diameters, which forming machine comprises at least a clamping device for clamping down a workpiece, a first ~~tool~~set of forming rollers, which can be placed into contact with the workpiece while being worked, means for rotating the workpiece and the first ~~tool~~set of forming rollers about an axis of rotation relative to each other, and means for moving the workpiece and/or the first ~~tool~~first set of forming rollers in a direction along said axis of rotation, and at least a second ~~tool~~set of forming rollers disposed behind said first ~~tool~~set of forming rollers, which can be placed into contact with the workpiece and wherein two or more forming rollers associated with different ~~tools~~sets of forming rollers are mounted on a common holder such that perimeters of adjacent forming rollers at least partially overlap and said holder is mounted in or on the forming machine in such manner as to be capable of rotation about an axis which crosses said axis of rotation and/or of radial translation during operation.

17. (Cancelled)

18. (Cancelled)

19. (Currently amended) The forming machine according to claim 16, comprising at least a third ~~tool~~set of forming rollers disposed behind said second ~~tool~~set of forming rollers.

20. (Currently amended) The forming machine according to claim 16, wherein the ~~tools~~first and second sets of forming rollers each comprise two or more forming rollers, between which the workpiece can be retained.

21. (Currently amended) The forming machine according to claim 16, wherein the ~~tools~~first and

second sets of forming rollers can be moved relative to each other during the working.

22. (Previously presented) The forming machine according to claim 16, comprising a mandrel or bush to be placed in or around, respectively, an unworked part of the workpiece, and by means of which a tensile force can be exerted on the workpiece.

23. (Cancelled)

24. (Cancelled)

25. (Cancelled)

26. (Cancelled)

27. (Cancelled)

28. (Previously presented) The method according to claim 1, wherein the workpiece comprises a metal cylinder or plate.